

Date: Wednesday, 2/15/2006 3:46:44 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, LEFT SIDE	
Job Number	: 25843				
Estimate Number	: 10833				
P.O. Number	: N/A		Part Number	: D29331	
This Issue	: 2/15/2006 S.O. No. : N/A		Drawing Number	: D2933 REV B	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: B	
Previous Run	: 25376		Material	: N/A	
Written By			Due Date	: 3/10/2006	
Checked & Approved By			Qty:	4 Um: Each	
Comment	: Est: B00.06.26 New DWG rev (mpp 2069) EC				
Additional Product					
Job Number:					
Seq. #:	Machine Or Operation:	Description:			
1.0	D6101001 	7075-T7351 2X6X6.25			
<p>Comment: Qty.: 1.0000 Each(s)/Unit Total : 400000 Each(s)</p> <p>Issue material from stock: 7075-T7351.QQ-A-250/12</p> <p>Cut Size 2.0 x 6.25 X 6.00</p> <p>Grain Along Long 6.00 Length</p> <p>Batch No: 24890 → 3 parts</p> <p style="text-align: center;">23734 → 1 part.</p> <p style="text-align: right;">SD 06.04.23</p>					
2.0	HAAS1 	HAAS CNC VERTICAL MACHINING #1			
<p>Comment: HAAS CNC VERTICAL MACHINING #1</p> <p>Program part number and batch number.</p> <p>1-Inspect part number and batch number are programmed correctly.</p> <p>2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet</p> <p>3-Machine Step No 2 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet</p> <p>4-Machine Step No 3 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet</p> <p>5-Deburr</p> <p style="text-align: right;">SD 06.04.23</p>					
3.0	MILLING CONV. 	CONVENTIONAL MILLING MACHINE			
<p>Comment: CONVENTIONAL MILLING MACHINE</p> <p>Machine Keyway and inspect per attached dimension sheet</p> <p style="text-align: right;">SD 06.04.23</p>					
4.0	QC1 	INSPECT ALL DIM TO DIM SHEET			
<p>Comment: INSPECT ALL DIM TO DIM SHEET</p> <p style="text-align: right;">SD 06.04.23</p>					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05.06.24	2	-1 part made with grain on wrong direction (bad billets batch) B23934	AB 06.06.24	Scraped surface surface. Ensure grain on billets is good. No replace. Set-up removed. Scraps all can not determine which	SD 06.06.24	✓ 06.06.24	AB 06.06.24	✓ 06.06.24

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:46:44 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, LEFT SIDE

Job Number: 25843

Part Number: D29331

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W.D.J. 2/15/06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

25843

Description: 206 Saddle, Inboard, Left side

Part Number:

D2933-1

Inspection Dwg: D2933 Rev. B

Page 1 of 1

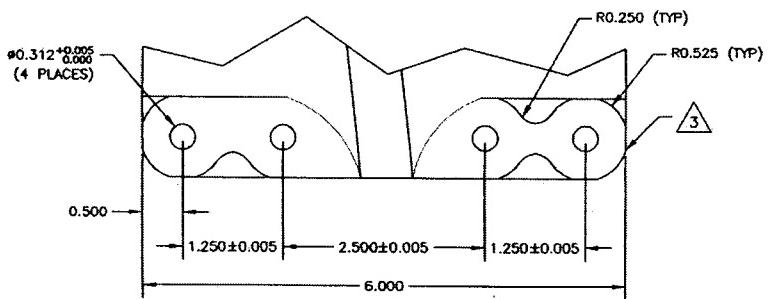
Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. B and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.129	.128	.126	.124		
B	0.100	0.140		.129	.128	.126	.124		
C	0.100	0.140		.120	.120	.120	.120		
D	0.210	0.230		.229	.223	.222	.221		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515							
I	1.572	1.582		1.578	1.578	1.578	1.578		
J	2.495	2.505		2.498	2.499	2.495	2.495		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240							
N	0.100	0.140		.124	.123	.123	.122		
O	0.540	0.560		.549	.548	.549	.547		
P	0.490	0.510		.502	.501	.501	.499		
Q	3.715	3.725		3.722	3.722	3.722	3.722		
R	2.470	2.510		2.498	2.499	2.499	2.498		
S	0.240	0.270		.263	.260	.255	.255		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.629	1.629	1.629	1.629		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.125	1.145		1.132	1.130	1.133	1.133		
Y	1.565	1.585	DT8695 A/B						
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	SD
Date:	06.04.23

Audited by	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	

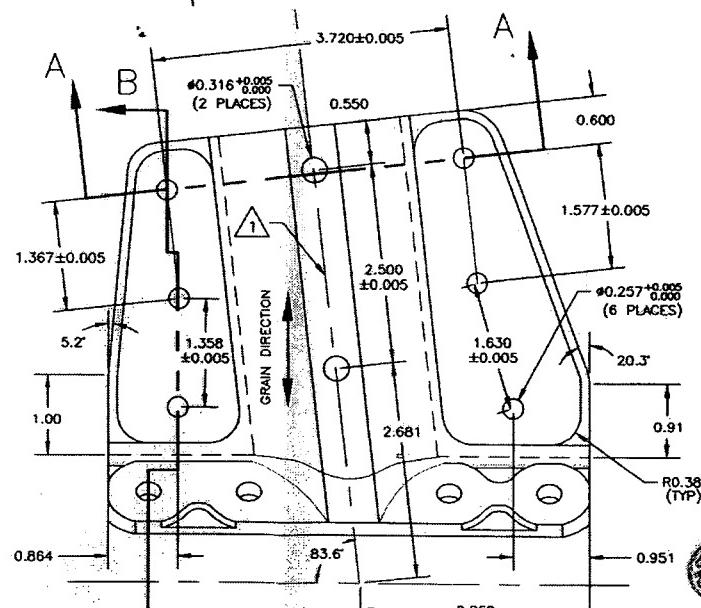
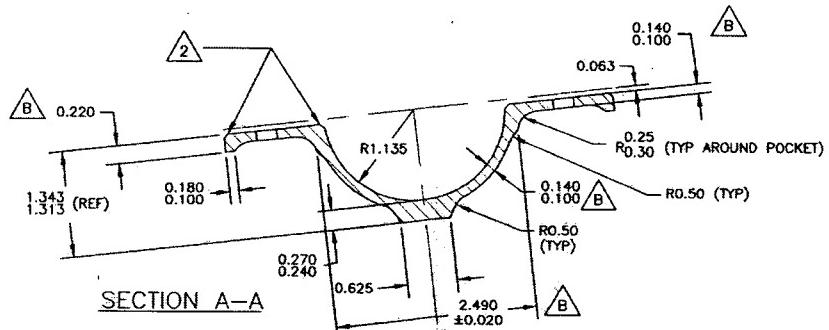
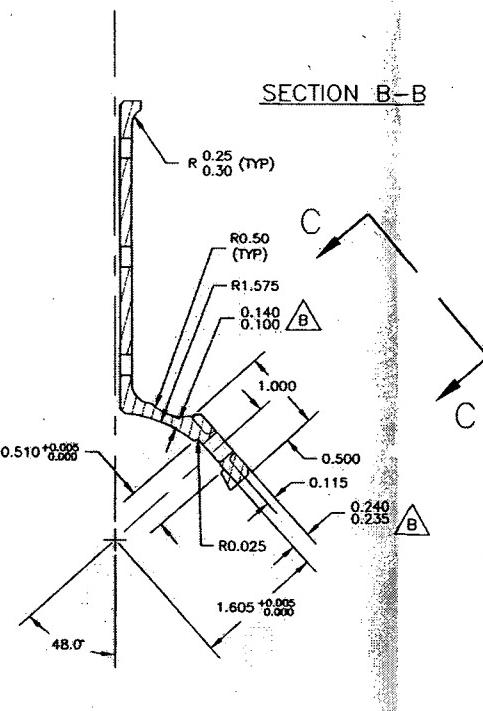


VIEW C-C

D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QO-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005.4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



RELEASED
 CD. 05. 31 43

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B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BEDFORD, VA
CHECKED	APPROVED	DRAWING NO. REV. B D2933 SHEET 1 OF 1
DATE	00.05.29	TITLE SCALE SADDLE INSIDE 2.3

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 ENGINEERING
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 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 25843



Linda Lacelle

From: Linda Lacelle [llacelle@dartaero.com]
Sent: Monday, April 24, 2006 11:25 AM
To: Carreiro, Mario - copp/bras (E-mail)
Subject: p.o 2008787

Hi Mario,
Just to let you know the billets D6101-001 on P.o 2008787- rec'd on Dec 30th,- the grain direction was on the wrong side.
We will use anyway, as these are abit oversized.

Thx
Linda